

Date: Monday, 2/5/2007 11:11:58 AM
 User: Chantal Lavoie

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	GUIDE
Job Number	30588		
Estimate Number	12687		
P.O. Number	JIA	Part Number	D35711
This Issue	2/5/2007	S.O. No.	JIA
Prsht Rev.	NC	Drawing Number	D3571 UNDER REVIEW
First Issue	2/2/2007	Project Number	N/A
Previous Run		Drawing Revision	U/R
Written By	<u>EE</u>	Material	JIA
Checked & Approved By		Due Date	2/9/2007
Comment	Est Rev:A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
Comment: Qty.: 0.2531 f(s)/Unit Total : 1.5183 f(s) 6061-T6 Bar .75" X 1.5" Batch: M102497 m102447 MS 07102105 (61)		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blank 2.90 " long MS 07102105 (7)		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A 2-Deburr per dwg D3571 MS 07102105 (61)		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE 		
Comment: CONVENTIONAL MILLING MACHINE C'SINK PARTS AS PER DWG D3571 		

WORK ORDER CHANGES

W/O:	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 11:11:59 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: GUIDE
Job Number: 30588		Part Number: D35711
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
7.0	QC8	SECOND CHECK ENGINEERING APPROVAL 
8.0	HAND FINISHING1	Comment: SECOND CHECK HAND FINISHING RESOURCE #1 
9.0	POWDER COATING	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 
10.0	QC3	Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 
11.0	PACKAGING 1	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 
12.0	QC21	Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location:  FOR ENGINEERING USE ONLY 
Comment: FINAL INSPECTION/W/O RELEASE Job Completion 		7/03/07 7/03/07 7/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

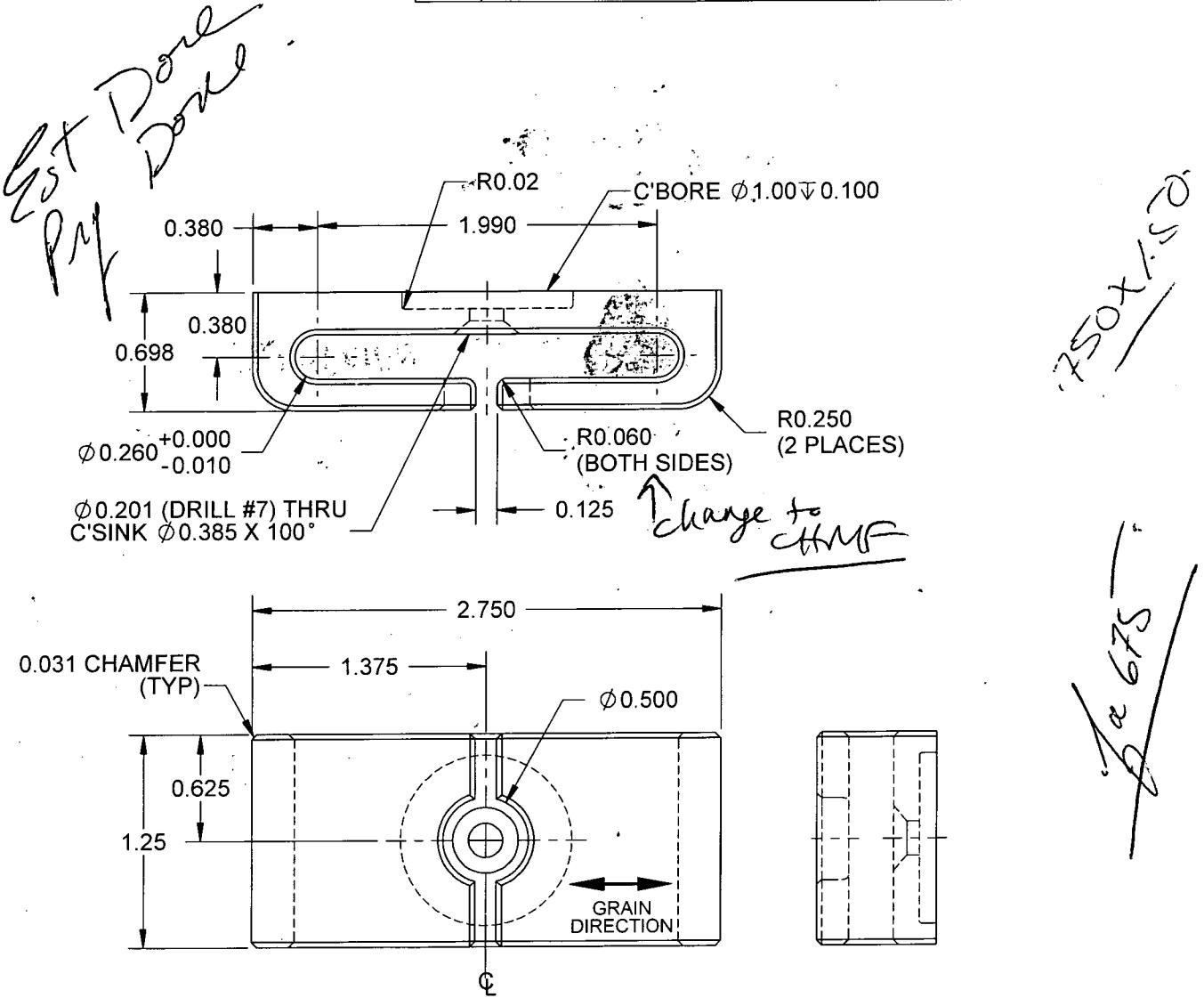
NOTE: Date & initial all entries

ELIMINATORY ISSUE

UNDER REVIEW

07-01-30 LC

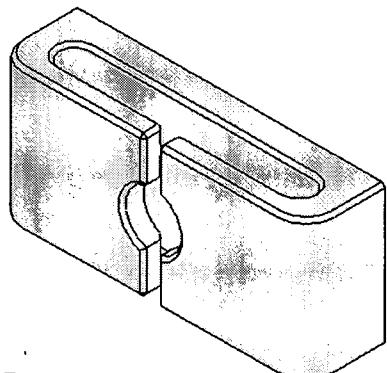
DESIGN CE	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED PH	APPROVED	DRAWING NO. D3571		
DATE 07.01.29		TITLE GUIDE		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE		SCALE 1:1



D3571-1 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT C



DART AEROSPACE LTD	Work Order:	3058
Description: Guide	Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article **X** Prototype

Measured by:

110

Date _____

Date: 07/02/05

Audited by:

W

Date _____

Date: 07/03/05

Prototype Approval:

ve

Date

07.03.21

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



INDALEX
ALUMINUM SOLUTIONS

48411
REFERENCE ONLY

Bundle
Number
13741
13742

MECHANICAL TESTING & CHEMICAL CERTIFICATION

<i>Customer</i>	<i>Date</i>	<i>Location</i>	<i>Test #</i>
ASA	3/24/2006	Mississauga	27166
<i>Customer #</i>	90	<i>Order #</i>	6031952
<i>Control #</i>	51722-1	<i>P.O. #</i>	057217-RK-1
<i>Cust Part #</i>	AF61.750X1.500	<i>Die #</i>	AS 7801
<i>Alloy & Temper</i>	6061 T6511	<i>Cast</i>	37398

Sample dimensions

<i>Width</i>	0.434	<i>Thickness</i>	0.343	<i>Area</i>	0.1489
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Test results

<i>Hardness</i>	<i>Yield Stress (PSI)</i>	<i>Min Required</i>	<i>Actual</i>
Rockwell	35,000	35,000	38,080
Webster B	38,000	41,114	41,114

Typical Chemistry

6061

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
0.4-0.8	0.7mx	0.15-0.4	0.15mx	0.8-1.20	0.04-0.35	0.05mx	0.25 mx	0.15mx

Tensile testing is performed according to ASTM B557.84 requirements
 Mechanical test results conform to specifications for ASTM B 221/SB221, ASTM B 308/B 308M
 except for Sec. 8.2 (Number of Specimens) which is determined by customer requirement

The aluminum extrusions tested meet the chemical composition requirements of the alloy specified.

Test certified by

MARQUEZ BAYASEN

Date

3/24/2006

Indalex Ltd.
 5675 Kennedy Rd.
 Mississauga, ON, L4Z 2H9

Tel: (905) - 890 - 8821
 Fax: (905) - 890 - 3670

Form #

Rev. Date: A

Receiving Report

REFERENCE ONLY

Date: 6/10/00
Supplier: MANA

Batch No: M102447
Dart P/O: 2273

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No
Shipment Complete: Yes No N/A
QC6 Inspection
Work Order

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>A133800</u>	<u>Acu 15X158</u>	<u>75</u>				

Initials of receiver (if shipment OK) Level 12 

Production/Admin:

Date 06/10/00

Received/Costing

Initial RCY

Location